

W/O:		74355 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2661-2 PAR #: N/A Fault Category: Program / Production NCR: Yes No DQA: lt Date: 11.10.25
11-914 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 11/10/25

NCR:		211.37 x 2 = 422.74 WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/03	100	About 1 inch of material is missing between the 2 bores Part is almost slit in half. 1 part scrapped B.C Programming error	<u>lt</u> 11/10/11 051042	→ scrap and destroy qtr. → program has been fixed and updated. B <u>72226</u>	<u>lt</u> B.A 11/10/03	SK 11-10-13 ↓	<u>lt</u> 11/10/11 051042	<u>S</u> 11/10/12
11/10/04	100	.250" of material is missing at the end of large bore at bottom of island. 3 rd app has not leave enough material to machine on 4 th app. B.C Programming error -		→ scrap and destroy qtr. → program has been fixed and updated. B <u>72226</u>	<u>lt</u> B.A 11/10/04		<u>lt</u> 11/10/11 051042	<u>S</u> 11/10/12
		LOA						

NOTE: Date & initial all entries

Work Order ID 74355



Page 2

Wednesday, September 28, 2011 3:26:04 PM

Item ID:	D2661-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, RH Fwd Aft Out 206					
Start Date:	9/28/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	10/7/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00				20	0		
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00				20	0		
150 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo	0.00							

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

8:30

9:00

3200F

M117745

20 BR 11-10-B

20X 0 MF 11/10/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74355

Wednesday, September 28, 2011 3:26:04 PM



Page 3

Item ID: D2661-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20
COUNT. / 11/10/18

170

Identify as per dwg & Stock Location: ST 476 0.00



Packaging

Memo

0.00

Packaging

SP 11-10-18.

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/10/18
20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, September 28, 2011 3:26:12 PM

Work Order ID: 74355



Parent Item: D2661-2



Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/28/2011

Required Date: 10/7/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	73.0000	1	20			

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT040

8

72226

8

MAT44

65

72226

5

✓ 73769

60

20.0

B.A 11/10/11

+

2.0 (same batch)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 74358
Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

1.125-1.145
 1.313-1.343
 11/10/11

				Recorded Actual Dimensions					Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5	
AB	0.100	0.140		0.113	0.111	0.111	0.114	0.114	
BA	0.100	0.140		0.115	0.115	0.115	0.115	0.116	
C	1.250	1.270		1.134	1.132	1.134	1.139	1.136	
D	0.615	0.685		0.680	0.680	0.680	0.680	0.680	
E	0.240	0.260		0.250	0.251	0.249	0.246	0.250	
F	1.437	1.467		1.323	1.322	1.322	1.324	1.323	
G	0.210	0.230		0.222	0.221	0.221	0.222	0.221	
H	0.100	0.180		0.135	0.135	0.135	0.135	0.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.574	1.572	1.573	1.578	1.576	
K	0.235	0.240		0.238	0.238	0.238	0.238	0.238	
L	0.100	0.120		0.113	0.113	0.113	0.113	0.113	
M	0.990	1.010		0.998	0.998	0.998	0.998	0.998	
N	0.510	0.515		0.513	0.513	0.513	0.513	0.513	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		0.315	0.315	0.315	0.315	0.315	
S	0.315	0.322		0.317	0.317	0.317	0.317	0.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		0.798	0.797	0.797	0.796	0.797	
W	0.540	0.560		0.550	0.550	0.550	0.550	0.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		0.258	0.258	0.258	0.258	0.258	
Z	0.912	0.932		0.921	0.922	0.922	0.922	0.922	
AA	0.490	0.510		0.500	0.499	0.498	0.500	0.500	
AB	0.178	0.198		0.188	0.188	0.188	0.188	0.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>BA</u>	Audited by: <u>DL</u>
Date: <u>11/10/11</u>	Date: <u>11-10-13</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 74358
Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 1 of 5

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					Date
				6	7	8	9	10	
A	0.100	0.140		0.114	0.112	0.112	0.114	0.112	
B	0.100	0.140		0.113	0.111	0.112	0.114	0.112	
C	1.250	1.270		1.1356	1.134	1.1353	1.1347	1.134	
D	0.615	0.685		0.680	0.680	0.680	0.680	0.680	
E	0.240	0.260		0.249	0.250	0.250	0.249	0.249	
F	1.437	1.467		1.323	1.323	1.323	1.323	1.323	
G	0.210	0.230		0.222	0.222	0.222	0.222	0.221	
H	0.100	0.180		0.135	0.135	0.135	0.135	0.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.5454	1.544	1.545	1.5446	1.544	
K	0.235	0.240		0.238	0.238	0.238	0.238	0.238	
L	0.100	0.120		0.113	0.113	0.113	0.113	0.113	
M	0.990	1.010		0.998	0.998	0.998	0.998	0.998	
N	0.510	0.515		0.513	0.513	0.513	0.513	0.513	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		0.315	0.315	0.315	0.315	0.315	
S	0.315	0.322		0.317	0.317	0.317	0.317	0.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		0.797	0.797	0.797	0.797	0.797	
W	0.540	0.560		0.550	0.550	0.550	0.550	0.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		0.258	0.258	0.258	0.258	0.258	
Z	0.912	0.932		0.922	0.921	0.922	0.922	0.922	
AA	0.490	0.510		0.497	0.496	0.501	0.500	0.500	
AB	0.178	0.198		0.188	0.188	0.188	0.188	0.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: H.A.	Audited by: J1
Date: 11/10/05	Date: 11-10-13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 74355
Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 3 of 5

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					Date
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15	
A	0.100	0.140		0.112	0.113	0.112	0.112	0.112	
B	0.100	0.140		0.112	0.114	0.112	0.110	0.112	
C	1.250	1.270		1.135	1.1378	1.134	1.134	1.135	
D	0.615	0.685		0.680	0.680	0.680	0.680	0.680	
E	0.240	0.260		0.250	0.247	0.250	0.248	0.247	
F	1.437	1.467		1.323	1.323	1.322	1.322	1.322	
G	0.210	0.230		0.222	0.223	0.221	0.220	0.221	
H	0.100	0.180		0.135	0.135	0.135	0.135	0.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.575	1.5746	1.574	1.574	1.575	
K	0.235	0.240		0.238	0.238	0.238	0.238	0.238	
L	0.100	0.120		0.113	0.113	0.113	0.113	0.113	
M	0.990	1.010		0.998	0.998	0.998	0.998	0.998	
N	0.510	0.515		0.513	0.513	0.513	0.513	0.513	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		0.315	0.315	0.315	0.315	0.315	
S	0.315	0.322		0.317	0.317	0.317	0.317	0.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		0.797	0.797	0.797	0.797	0.797	
W	0.540	0.560		0.550	0.550	0.550	0.550	0.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		0.258	0.258	0.258	0.258	0.258	
Z	0.912	0.932		0.922	0.922	0.922	0.922	0.922	
AA	0.490	0.510		0.501	0.502	0.503	0.501	0.501	
AB	0.178	0.198		0.188	0.188	0.188	0.188	0.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>BA</u>	Audited by: <u>JL</u>
Date: <u>11/10/05</u>	Date: <u>11-10-13</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 74358
Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 4 of 4





Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

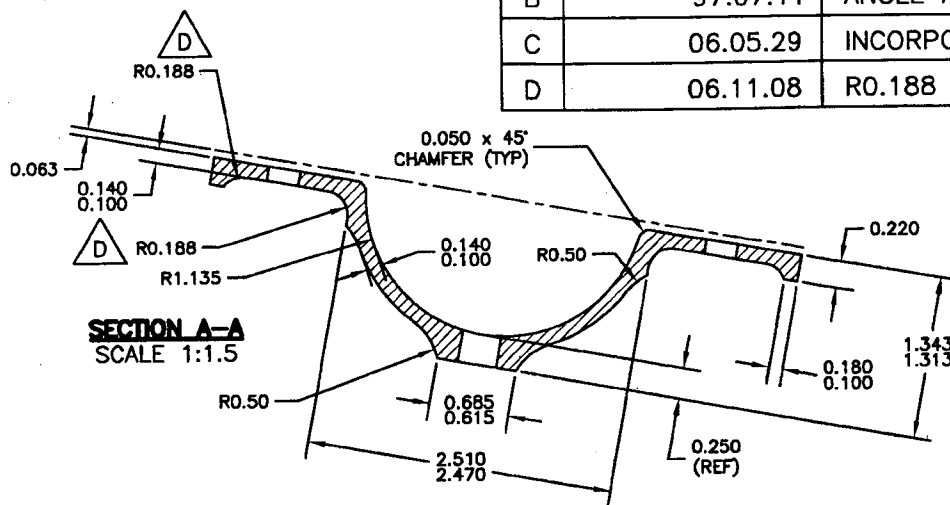
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					Date
				16	17	18	19	20	
A	0.100	0.140		0.112	0.113	0.113	0.113	0.113	
B	0.100	0.140		0.112	0.111	0.110	0.110	0.113	
C	1.250	1.270		1.135	1.134	1.132	1.132	1.136	
D	0.615	0.685		0.680	0.680	0.680	0.680	0.680	
E	0.240	0.260		0.247	0.249	0.248	0.248	0.247	
F	1.437	1.467		1.322	1.322	1.322	1.322	1.323	
G	0.210	0.230		0.220	0.220	0.220	0.220	0.222	
H	0.100	0.180		0.135	0.135	0.135	0.135	0.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.575	1.574	1.572	1.572	1.576	
K	0.235	0.240		0.238	0.238	0.238	0.238	0.238	
L	0.100	0.120		0.113	0.113	0.113	0.113	0.113	
M	0.990	1.010		0.998	0.998	0.998	0.998	0.998	
N	0.510	0.515		0.513	0.513	0.513	0.513	0.513	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		0.315	0.315	0.315	0.315	0.315	
S	0.315	0.322		0.317	0.317	0.317	0.317	0.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		0.797	0.797	0.797	0.797	0.797	
W	0.540	0.560		0.550	0.550	0.550	0.550	0.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		0.258	0.258	0.258	0.258	0.258	
Z	0.912	0.932		0.922	0.922	0.922	0.922	0.922	
AA	0.490	0.510		0.495	0.501	0.501	0.501	0.501	
AB	0.178	0.198		0.188	0.188	0.188	0.188	0.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>B.A.</u>	Audited by: <u>JL</u>
Date: <u>11/10/06</u>	Date: <u>11-10-13</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN 		DRAWN BY 		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2661	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE OUTSIDE		SCALE 1:3	
A	97.03.25	NEW ISSUE			
B	97.07.11	ANGLE AND NOTES ADDED			
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095			
D	06.11.08	R0.188 WAS R0.30; \varnothing 0.316 WAS \varnothing 0.313			



RELEASED

07.02.12

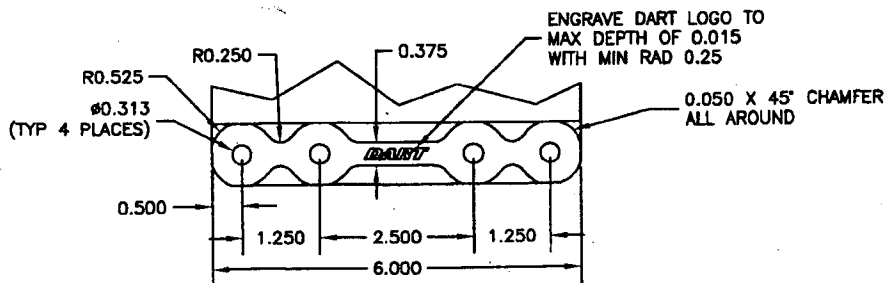
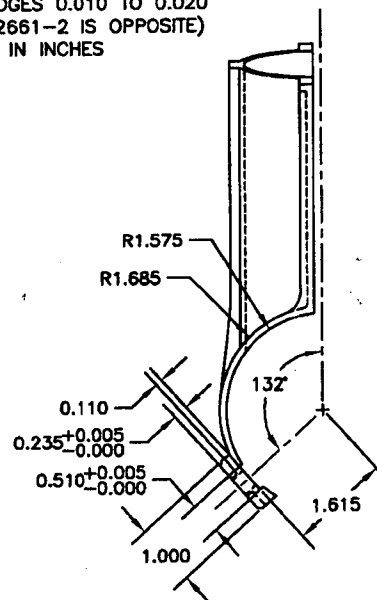
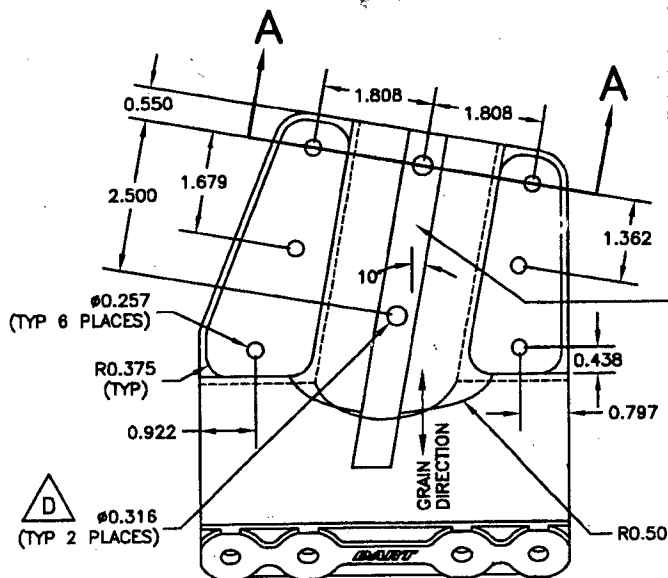
SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

M.C. 5
11/09/28

74355

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T735N((00-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2661-1 SADDLE OUTSIDE**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries